

Work Order ID 50862

July 23, 2009 9:17:40 AM



Page 1

Item ID: D3955-041
Revision ID: A
Item Name: Doubler Assembly

Accept



Setup Start



Stop



Start Date: 7/23/2009 Start Qty: 2.00
Required Date: 7/23/2009 Req'd Qty: 2.00



Cust Item ID:
Customer:



Reference:

Approvals: Process Plan:  Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start
Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3955 | A | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
|  | | | | | | | | | |
| Waterjet | | | | | | | | | |
| FLOW CNC Waterjet | | | | | | | | | |
| | Memo | 0.00 | | | | | | | |
| | 1-Cut as per Dwg D3955-1 | | | | | | | | |
| | Dwg Rev: <u>A</u> | | | | | | | | |
| | Prog Rev: <u>A</u> | | | | | | | | |
| | 2-Deburr if necessary | | | | | | | | |
| 110 | | 0.00 | | | | | | | |
|  | | | | | | | | | |
| QC | | | | | | | | | |
| Quality Control | | | | | | | | | |
| | Memo | 0.00 | | | | | | | |

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HB 9-7-23

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Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

0.00



Small Fab

Memo

0.00

Small Fab

1- C'sink holes as per dwg

2- Deburr if necessary

09/07/23 6

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

weight = .225 lbs

0.00

Quality Control

07/23

46 6

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

M-1 09/07/23



160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

SS 09/07/23



170

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

09/17/23



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Setup Start



Stop



Start Date: 7/23/2009 Start Qty: 2.00
Required Date: 7/23/2009 Req'd Qty: 2.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Small Fab

Small Fab

Memo

1- Assemble nut plate as per dwg

0.00

0.00

EP 09/07/23 (2) 6

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=> 8 09/09/23

(x6) 6

200



Packaging

Packaging

Identify as per dwg & Stock Location: 139

Memo

0.00

0.00

19/1/23 C

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Item ID: D3955-041

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Start Date: 7/23/2009 Start Qty: 2.00

Required Date: 7/23/2009 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control



Accept



Setup Start



Stop



Cust Item ID:

Customer:



09/07/23 JF

CMF 09-07-23

Picklist Print

July 23, 2009 9:17:39 AM

Page 1

Work Order ID: 50862

Parent Item: D3955-041RevA

Parent Item Name: Doubler Assembly


Comments:

Start Date: 7/23/2009

Required Date: 7/23/2009

Start Qty: 2.00

Required Qty: 2.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6S.063 | | Purchased | No | | | 100 | sf | 135.2173 | 0.7480 | | | |
| <div>  </div> | | | | | | | | | | | | |
| 6061-T6 .063 Sheet | | | | | | | | | | | | |

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT

135.2173316

109463

0.6447

110551

134.572632

MS210861.3

Purchased

No

180

Each

49.0000

2.0000



Nut Plate

110551

HB 9-7-03

6

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

49

112219

49

MS20427M3-3

Purchased

No

180

Each

412.0000

4.0000



Rivet

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

412

110022

115

111819

297

SB 09/07/20

| | | |
|--|--|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 50862 |
| Description: Doubled Assembly | | Part Number: D3955-1 |
| Inspection Dwg: D3955-1 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

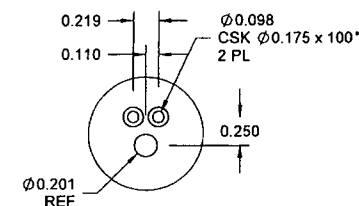
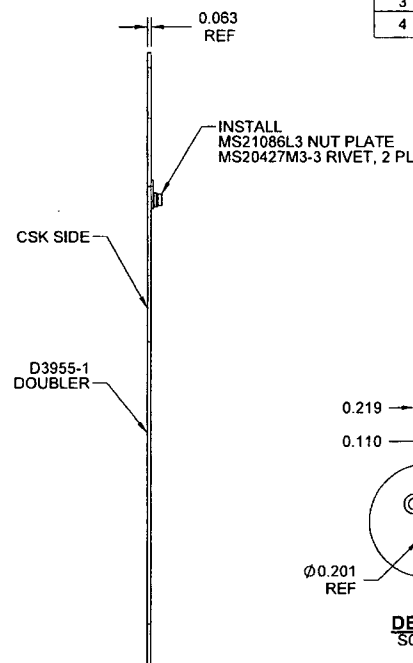
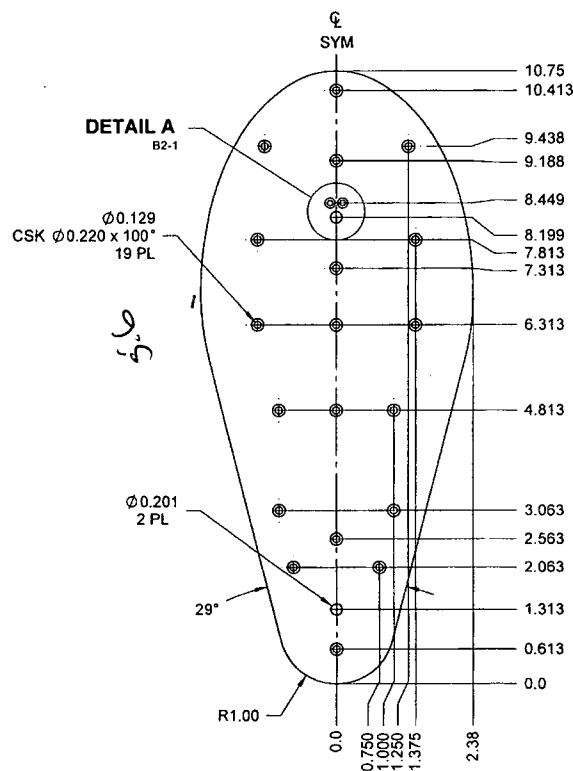
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø .129 | + .005 - .001 | .130 | X | | | |
| Ø .261 | + .005 - .001 | .263 | X | | | |
| .1750 | +/- .010 | .1750 | X | | | |
| 1.000 | +/- .010 | .999 | X | | | |
| 1.250 | +/- .010 | 1.251 | X | | | |
| 1.375 | +/- .010 | 1.374 | X | | | |
| 2.38 | +/- .030 | 2.380 | X | | | |
| .613 | +/- .010 | .611 | X | | | |
| 1.313 | +/- .010 | 1.312 | X | | | |
| 2.063 | +/- .010 | 2.061 | X | | | |
| 2.563 | +/- .010 | 2.564 | X | | | |
| 3.063 | +/- .010 | 3.063 | X | | | |
| 4.813 | +/- .010 | 4.815 | X | | | |
| 6.313 | +/- .010 | 6.314 | X | | | |
| 7.313 | +/- .010 | 7.314 | X | | | |
| 7.813 | +/- .010 | 7.815 | X | | | |
| 8.199 | +/- .010 | 8.198 | X | | | |
| 8.449 | +/- .010 | 8.447 | X | | | |
| 9.188 | +/- .010 | 9.189 | X | | | |
| 9.438 | +/- .010 | 9.436 | X | | | |
| 10.413 | +/- .010 | 10.313 | | | | 09.07.23 |
| 10.75 | +/- .030 | 10.748 | X | | | |
| .063 | +/- .010 | .065 | X | | | |

| | | |
|------------------------|-----------------------|----------------------------|
| Measured by: IB | Audited by: S | Prototype Approval: |
| Date: 9-7-23 | Date: 09/07/23 | Date: |

| | | | | |
|------------|-------------|---------------|-------------------|-----------------|
| Rev | Date | Change | Revised by | Approved |
| A | | New Issue | KJ/JLM | |

[Signature]

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-------------|--------------|
| 1 | X | D3955-041 | DOUBLER ASSY |
| 2 | 1 | D3955-1 | DOUBLER |
| 3 | 1 | MS21086L3 | NUT PLATE |
| 4 | 2 | MS20427M3-3 | RIVET |







D3955-1 DOUBLER

D3955-1 NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

D3955-041 DOUBLER ASSEMBLY

| | | | | | | | | | |
|------------|--|---|--|---|--|----------|--|--------------|--|
| A | | NEW ISSUE | | RF | | 09.07.21 | | | |
| REV. | | DESCRIPTION | | | | BY | | DATE | |
| DESIGN | | DS | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | | | | |
| DRAWN | | RF | | | | | | | |
| CHECKED | |  | | DRAWING NO. | | | | REV. A | |
| MFG. APPR. | |  | | D3955 | | | | SHEET 1 OF 5 | |
| APPROVED | |  | | TITLE | | | | SCALE | |
| DE APPR. | |  | | SKIDTUBE TUNING KIT | | | | NTS | |
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